

Work Order ID 66936 - 1

Thursday, March 03, 2011 8:41:53 AM

Page 1

Item ID: D2230-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug

Start Date: 3/3/2011 Start Qty: 100.00

Required Date: 3/11/2011 Req'd Qty: 100.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: 11-03-3 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch:

Cut @ 4 meters

CZ 11/03/04

110

0.00



HAAAS CNC VERTICAL MACHINING #1

HAAAS T

Memo

0.00

HAAAS CNC vertical machine #1

1-Machine per folio FA927

FOLIO REV:

DWG REV:

Check for crack while loading into the machine.

2- deburr

Issue P/O to 4 meters P/O 13611

CZ 11/03/04 (160)

Purchasing

Machine as per drawing D2230 REV.G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66936

Thursday, March 03, 2011 8:41:53 AM



Page 2

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 3/3/2011 Start Qty: 160.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 160.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

rec'd + inspect for transit damage
attached c/c to w/o

10/13/21 (105)

130

QC3- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

8/10/22

counts
(x105)

150

Chemical Conversion Coat per QS1005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

105 BL 11-3-22

W/O:		WORK ORDER CHANGES					
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Thursday, March 03, 2011 8:41:53 AM



Page 3

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/3/2011 Start Qty: 160.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 160.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(105X) m-d 11/03/22

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

MIIS951

Memo

0.00

Powder Coating

START TIME: 3:20

OVEN TEMPERATURE: 320 °F

FINISH TIME: 3:50

(105X) m-d 11/03/22

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

105 BL 11-3-22

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

Identify as per dwg & Stock Location

5470

0.00



Packaging

Memo

0.00

Packaging

4/3/11/03/23 (105)

200

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/2307
mf
11-03-23

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 8:42:04 AM

Page 1

Work Order ID: 66936

Parent Item: D2230-3

Parent Item Name: Lug



Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP ID: 00.05.18 Added inspection level 8, and removed P/O for powder coat EC
IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	485.9514	0.0683	11.50316			



Lug Extrusion



02/11/03/04

Location	Loc Qty	Loc Code
MAT06	485.9514265	
43722	180	
45800	17.9514265	
63005	288	

11.50316

D2230-3P

Qty 160

3/4/3/21 (1.05)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

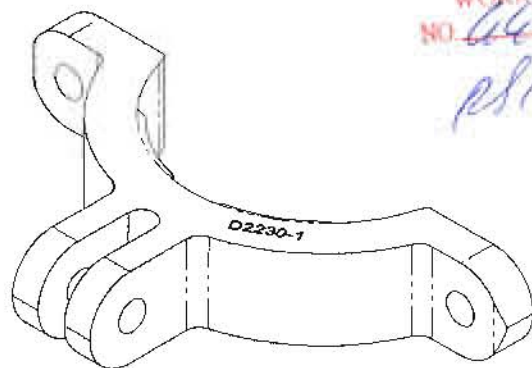
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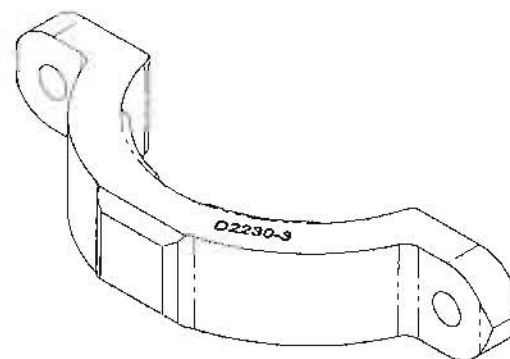
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44936

PS11-033



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
09/01/16



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 010 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.18 lbs
-3: 0.14 lbs

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO. D2230	REV. G
MFG. APPR	AS	SHEET 1 OF 3	
APPROVED	AS	TITLE	SCALE
DE APPR	AS	MOUNTING LUG	NTS
DATE	09.01.16	<small> COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED TO THE PUBLIC OR TO ANY OTHER PARTY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. </small>	

W/O:		WORK ORDER CHANGES					
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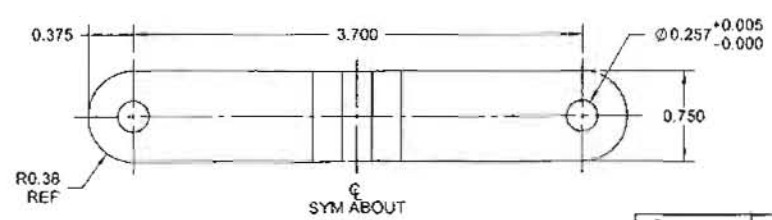
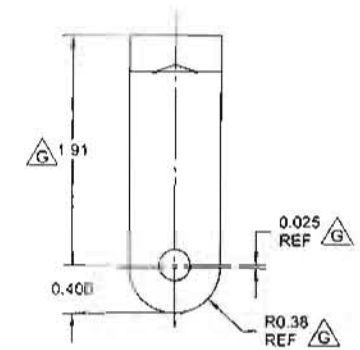
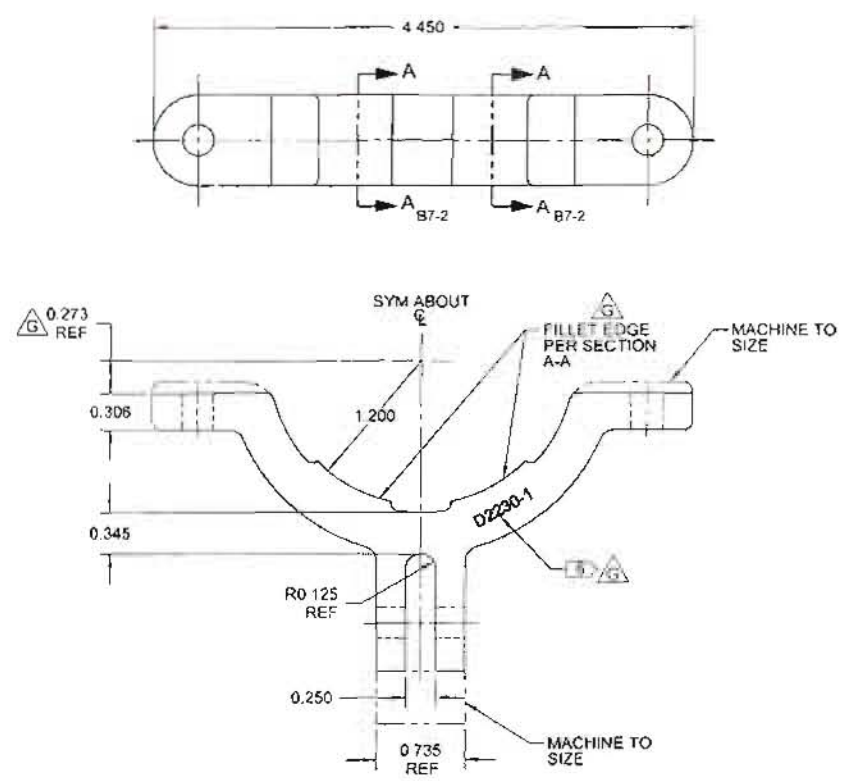
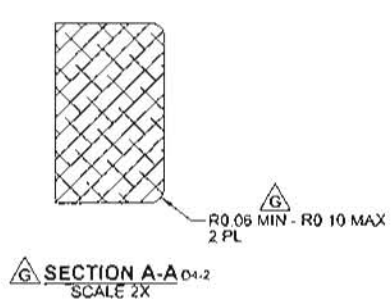
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NOTE: Date & initial all entries

u/o 46934



D2230-1 MOUNTING LUG

RELEASED
09/06/75

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. G
MFG. APPR		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval OC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO13611

Purchase Order Date 3/4/2011
PO Print Date 3/10/2011

Page Number 1 of 1

Order From : VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

REVISED
\$

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-3P	LUG	3/23/2011 Yes	160.00 Each	MC15	\$13.6000	\$2,176.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B66936				
2	D3235-1P	lug	3/18/2011 Yes	60.00 Each	✓	\$15.0500	\$903.00
		Special Inst:	MACHINE AS PER DWG D3235 REV. A B66941				
PO Total:							\$3,079.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 3

Change Date: 3/10/2011



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17836
Date: Mar 21, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13611	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug Material supplied by DART D2423 B	Each	160	105	55
D3235-1 Mounting Lug Material supplied by DART D2423 B	Each	60		
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

105

D2230-3P

Mounting Lug

13611

MATERIAL: supplied by DART D2423 B63005

8 u/03/27

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, March 21, 2011